

Work Order ID 67843

Thursday, March 31, 2011 3:39:24 PM

Page 1

Item ID: D3806-1

Accept

Revision ID:

Item Name: Bar

Start Date: 3/31/2011 Start Qty: 6.00

Required Date: 4/7/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *MF* Date: *11-03-31* Tooling:

QC: Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3806	Rev A

100 0.00



Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3806
Dwg Rev: _____
Prog Rev: _____

2-Deburr if necessary

Manual Mill

110 0.00



QC
Quality Control

Memo

11/04/04

(6)

Phu ->

11/04/04

(6)

W/O: 67843		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/15	#100	sec PAR 4-98 for Qty change					S 11/04/15

Part No: D3806-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67843

Thursday, March 31, 2011 3:39:24 PM



Item ID: D3806-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 3/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Y.A

11/04/04

6

0

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

Emi
WA

11/4/04

sl/60

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/04

MF
11-04-05

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Picklist-Print

Thursday, March 31, 2011 3:39:21 PM

Page 1

Work Order ID: 67843



Parent Item: D3806-1



Parent Item Name: Bar

Start Date: 3/31/2011

Required Date: 4/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-09-30 redesign DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.500X2.50

Purchased

No

f

22.0000

5.305263



304 BAR .500 x 2.50

Location

Loc Qty

Loc Code

MAT050

22

112764

16

116135

6

304 B 0.250 X 0.500

117176

22'

11/04/04

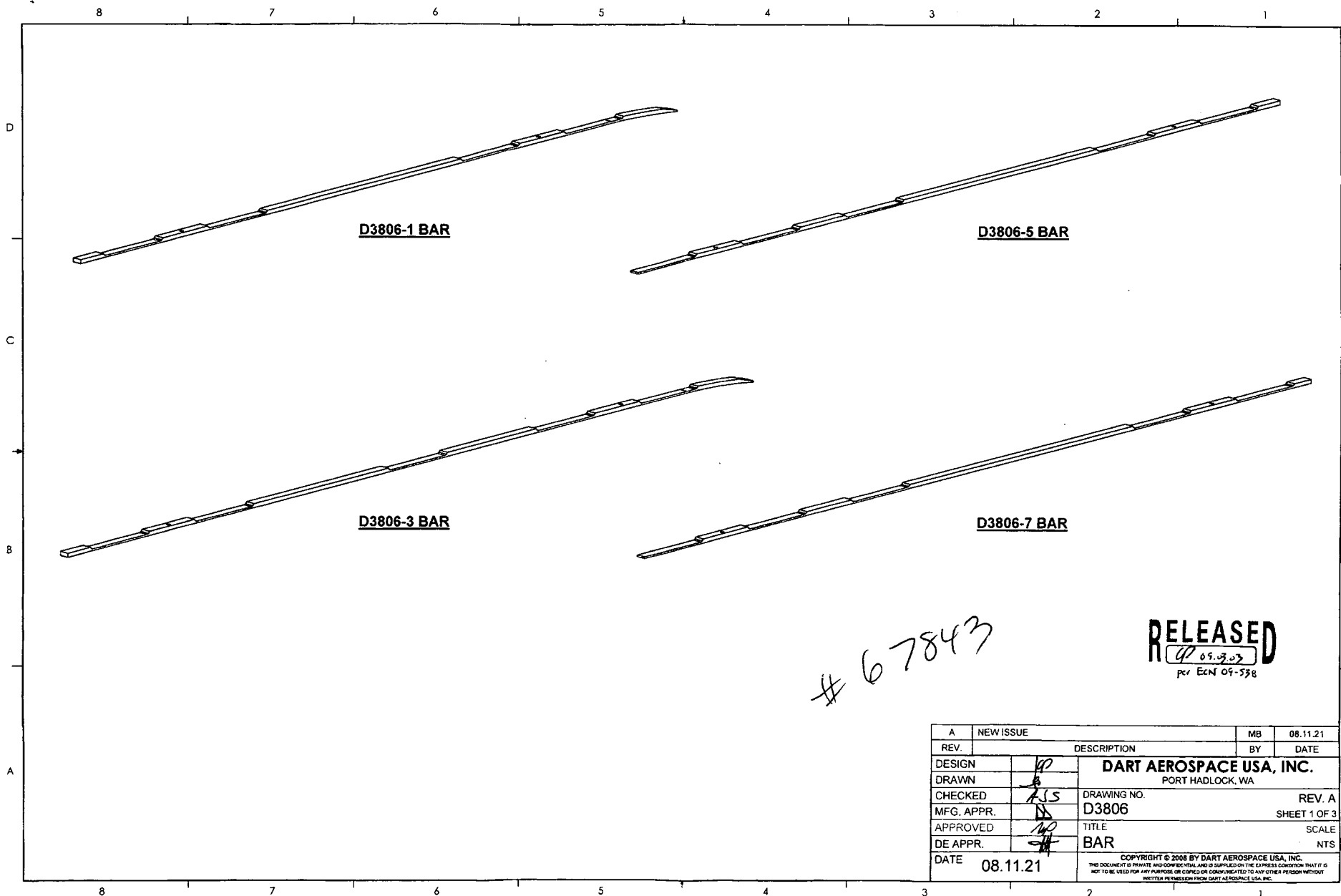
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	215	DRAWING NO.	REV. A
MFG. APPR.	DS	D3806	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAR	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

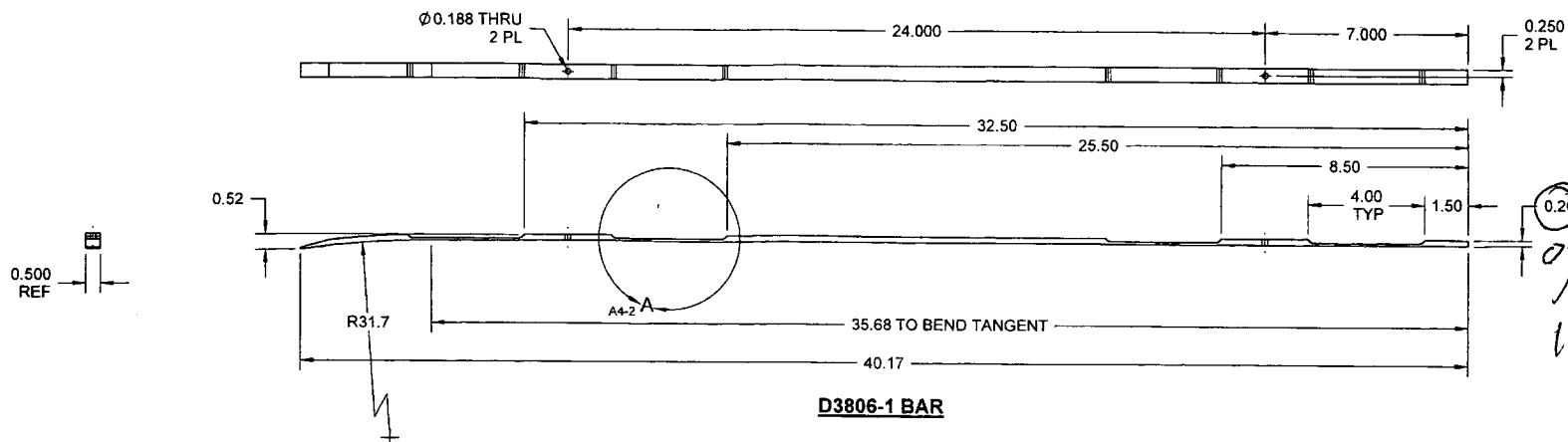
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

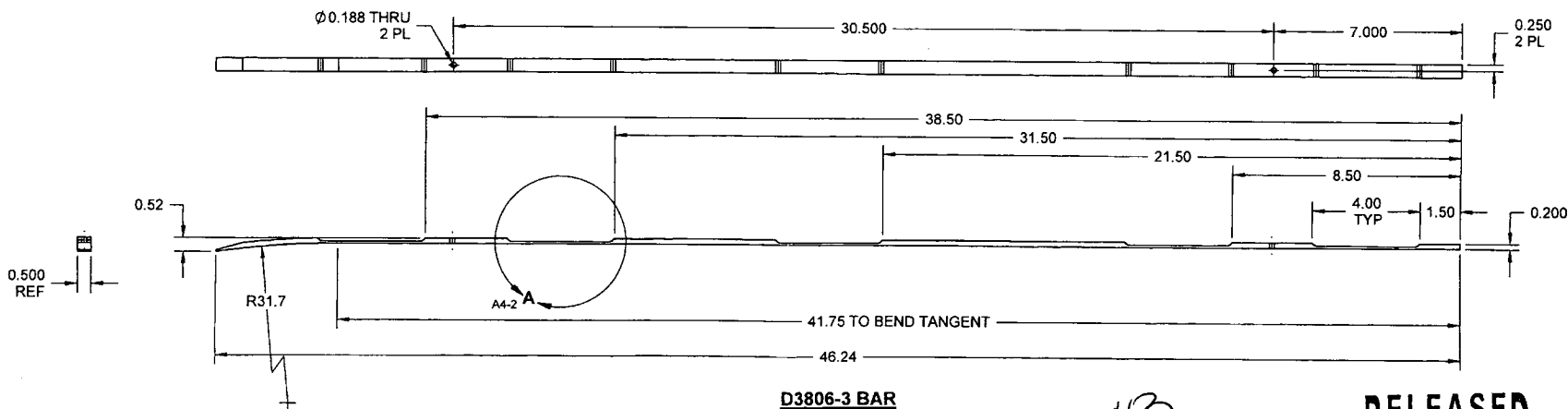
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8 7 6 5 4 3 2 1

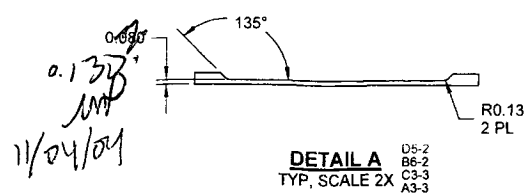


D3806-1 BAR



D3806-3 BAR

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 0.87 lbs
D3806-3 = 0.98 lbs



DETAIL A
TYP, SCALE 2X

RELEASED
47 04.03.03

DESIGN	142	DART AEROSPACE USA, INC.	
DRAWN	142	PORT HADLOCK, WA	
CHECKED	142	DRAWING NO.	REV. A
MFG. APPR.	142	D3806	SHEET 2 OF 3
APPROVED	142	TITLE	SCALE
DE APPR.	142	BAR	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

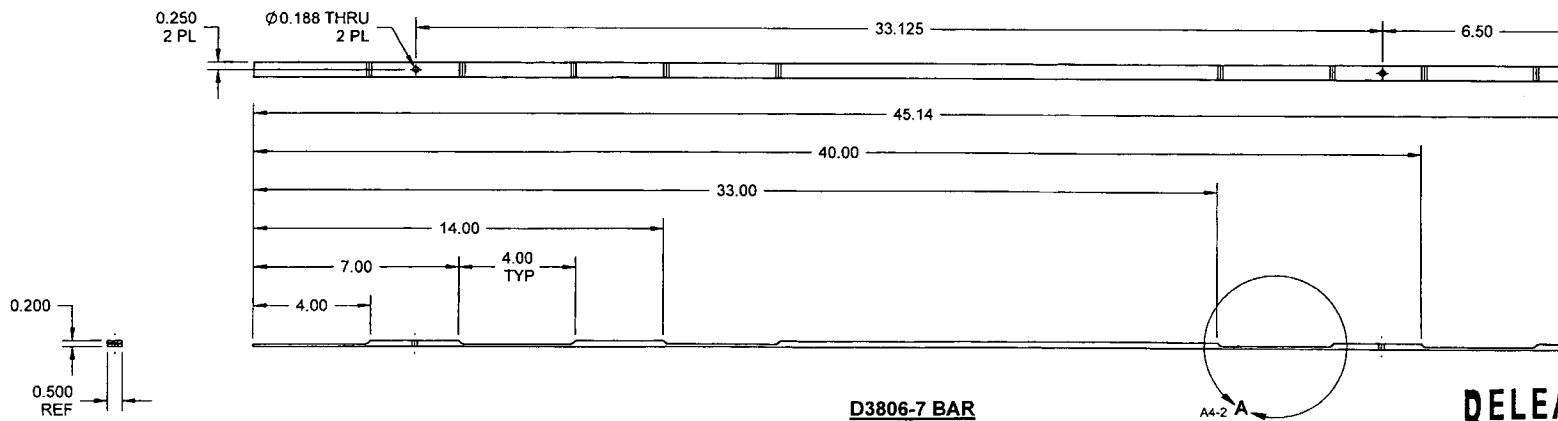
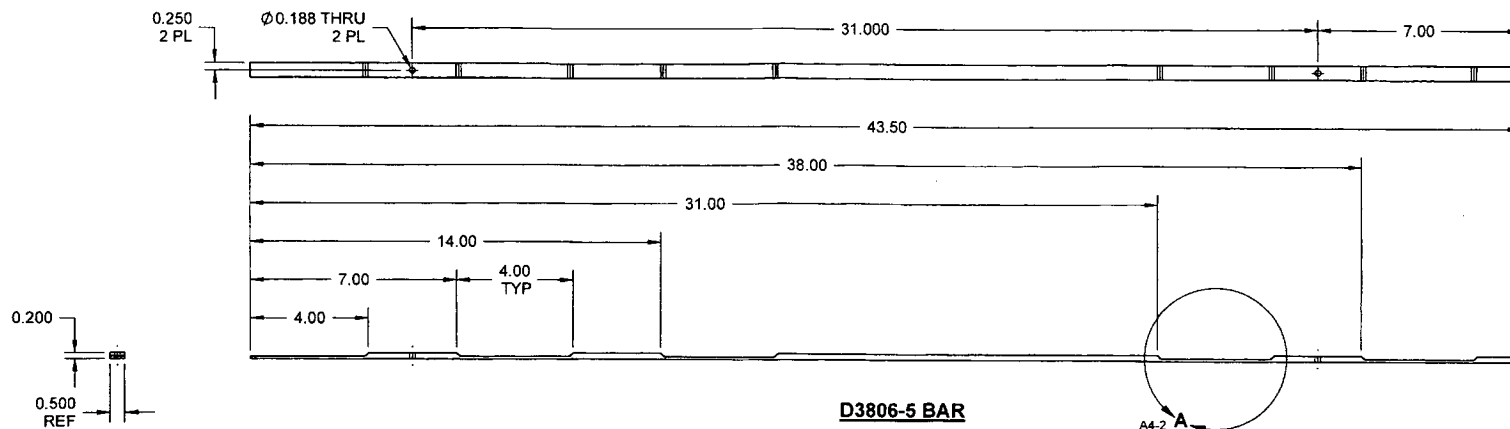
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 0.91 lbs
D3806-7 = 0.97 lbs

RELEASED
08.03.03

#67843

DESIGN	40	DART AEROSPACE USA, INC.	
DRAWN	40	PORT HADLOCK, WA	
CHECKED	2.55	DRAWING NO.	REV. A
MFG. APPR.	40	D3806	SHEET 3 OF 3
APPROVED	40	TITLE	SCALE
DE APPR.	40	BAR	NTS
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Employee Suggestion

Printed on:

April 5, 2011

Details			
Number PAR11-97	Status Open	Owner Petsche, Mike	Raised Date 05/04/2011
Source Employee Suggestion	Standard		Target Date 05/06/2011
Raised By Person Downing, Eric	Severity	Raised Against (Department or Supplier) Engineering\Drawing	Fault Category
Audit			
Details D3806 rev A should be changed due to material thickness changes. material was .200 and now is .250" on all parts. D3806-1/-3/-5/-7.			
Process ENGINEERING		Product Service	
Document			Root Cause
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 30/05/2011	Owner Petsche, Mike	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Petsche, Mike	08/04/2011	
place drawing under review			
2	Petsche, Mike	30/05/2011	
correctly update drawing			

Follow Up			
Target Date 09/04/2011	Owner	Closed Date	Closed By
Details Follow Up required			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	